Work Order ID 57981 April 21, 2010 10:06:10 AM				Page
Item ID: D130-780-011 Revision ID: Aft I H Door Hings	Accept		Setup Sta	
Item Name: Aft LH Door Hinge Start Date: 21/04/2010 Start Qty: 1.00 Required Date: 28/04/2010 Req'd Qty: 1.00 Reference:				op
Approvals: Process Plan: QC:	Date: //> Date: SPC (Y/N):	Date: Date:	Run Sta	
Sequence ID/ Operation	Set Up/	Draw Draw Plan Acce	ept Reject	Reject Insp.

Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Oty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr								.,,,,		-
DCI 0502	Δ	:									

DSI 9502 IIN-D130-780 В 100

0.00

Memo

0.00

Document Control

Photocopy bluefile &type labels per PPP D130-780-011 CHG 003

3 colul 28

110

Pick Kit

Packaging

Memo

0.00

0.00

10-4-21

Page 1

Packaging

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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			ş								
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	Date: _			
				ion:							
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC	Corrective Action Section B			Veriticatio			Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Approval Chief Eng	QC Inspector		
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Work Order ID 57981

April 21, 2010 10:06:10 AM



Page 2

Item ID:

D130-780-011

Revision ID:

Item Name:

Aft LH Door Hinge

Start Date: **Required Date: 28/04/2010**

Start Otv: 1.00 21/04/2010

Rea'd Otv: 1.00



Accept



Cust Item ID:

Customer:

Draw

Run

Setup Start





Reference:

Approvals:

Process Plan: Date:

QC: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop

Sequence ID/ Work Center ID

120

Operation Description

QC4- 100% Inspect kits for completeness

Set Up/ **Run Hours**

Draw Number Rev.

Plan Code

Accept Otv

Reject Oty

10-4-2

Reject Insp. Number Stamp

Quality Control

Memo

130

Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPP D130-780-011

Location:

QC21- Final Inspection Work Order Release

PPP rev:

140

Quality Control

Memo

0.00

0.00

10/04/289/ MF

Dart Aerospac	е	Ltd
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W/O:			V	VORK ORDER CHAI	NGES					1
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										1≢:
Part No		PAR #:								
	R	esolution:	_ Disposit	ion:	QA:	N/C Clo	sed:		Date:	
NCR:	·	W	ORK OR	DER NON-CONFOR	MANCE	(NCR)			
DATE	STEP	STEP Description of NC		Corrective Action Section B				erification Approve		
		Section A	Chief Eng	Chief Eng	JII	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Picklist Print April 21, 2010 10:06:15 AM Work Order ID: 57981 Parent Item: D130-780-011 Parent Item Name: Aft LH Door Hinge **Start Date: 21/04/2010** Required Date: 28/04/2010 IPP Rev:A 09-02-03 new issue DD verified by:JLM Comments: IPP Rev:B as Start Qty: 1.00 Required Oty: 1.00 per DSI 9502 revA DD 10.02.17 verified by:EC Component Item 1D/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Date Item Name 1 D180-780-015 Item ID Purch Item Location Location Seq ID Measure Issued Hand Qty To Pick Issued Manufactured No 110 110000 Each 1.0000 HUTW1 Closeout Installation Warehouse Loc Qty Loc Code Location Main Warehouse FG 53145 Manufactured No 110 Each 10.0000 0000 10-4-27 € Door Prop Warehouse Loc Qty Loc Code Location Main Warehouse ST272A 10 56392 10 Manufactured No 110 Each 100.0000 1.0000 10-4-27 8 Warehouse Loc Oty Loc Code

7 mesons

Location Main Warehouse ST416 100 47330 100 Page 1

Status

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cat	egory:	NCR : Ye	s No DQ	A:	Date:			
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NCR:			WORK ORE	DER NON-CONFORM	IANCE (NO	R)	•				
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April 21, 2010 10:06:15 AM

Page 2

Work Order ID: 57981

Parent Item:

D130-780-011

Parent Item Name:

Aft LH Door Hinge

Comments:

IPP Rev:A 09-02-03 new issue DD verified by:JLM

per DSI 9502 revA DD 10.02.17 verified by:EC



IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Hinge Assembly, Upper Door

Repla	acement
Item	ID

Mfg/ Purch Manufactured

Bin Primary Item Location No

Last Location Route Seq ID 110

Unit of Measure Each

Qty on Hand 7.0000

Remaining **Qty To Pick** 1.0000

Qty Issued

Date Issued

Status

Warehouse Location

Loc Qty

Loc Code

Main Warehouse

ST090

50349 53043

110

5.0000

1.0000



Hinge Assembly, Lower Door



No

Loc Qty

Each

Loc Code

10-4-275

Hinge, Upper Airframe

Manufactured No

Manufactured

Main Warehouse ST090 53044

Warehouse

Location

5 5 110 Each

Loc Qty

11.0000

Loc Code



10-4-27 Sl

Location
Main Warehouse
ST091
45673

Warehouse

11 50119 50261

April 21, 2010 10:06:15 AM

Shop Packet Print

Page 2

W/O:			W	ORK ORDER CHANGE	ES					
DATE	STEP	PROC	EDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	_ Fault Cat	egory:	NCR: Yes	No DQ	4 :	Date:		
	Resolution:			on:	QA: N/C Clo	osed:		Date: _		
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCR)				
DATE	CTED	STEP Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval
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April 21, 2010 10:06:15 AM

Page 3

Work Order ID: 57981

Parent Item:

D130-780-011

Parent Item Name:

Aft LH Door Hinge

Comments:

IPP Rev:A 09-02-03 new issue DD verified by:JLM

per DSI 9502 revA DD 10.02.17 verified by:EC



IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/

Item Name 4D3814-3 Replacement Mfg/ Item ID

Purch Manufactured

Manufactured

Manufactured

Bin Primary Item Location No

Last Location

Route Seq ID 110

110

110

Unit of Measure Each

Qty on Hand 17.0000

Loc Code

Remaining Qty To Pick Issued

Qty

Date Issued

Status

Hinge, Lower Airframe

Warehouse Location Main Warehouse

ST091

50120 50475

17 5 12

Each

Loc Qty

18.0000 2.0000

Loc Code

10 -4.27

D3816-1

Spacer

D3816-3

Spacer

Warehouse Location Main Warehouse

No

No

ST091

45675

18 Each

20

20

Loc Qty

18

Loc Oty

20.0000

Loc Code

Location Main Warehouse ST091

Warehouse

52930

W/O:			V	VORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CH	HANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	lo DQA:	Date: _	
				osition: QA: N/C Closed: Date:				
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC	1		ion B	Verification		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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April 21, 2010 10:06:15 AM

Page 4

Work Order ID: 57981

Parent Item:

D130-780-011

Parent Item Name:

Aft LH Door Hinge

Comments:

IPP Rev:A 09-02-03 new issue DD verified by:JLM

per DSI 9502 revA DD 10.02.17 verified by:EC



Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D3817-041

Replacement Mfg/ Item ID Purch

Bin Item Manufactured No

Primary Location

Warehouse

Location Main Warehouse ST092

Last Location

IPP Rev:B as

Route Seq ID 110

Unit of Qty on Measure Hand Each 20.0000

Remaining **Qty To Pick** 1:0000

Qty Issued Date **Issued**

Status

Anchor Nut Plate

Loc Qty

20

20

Loc Code

10-4.97 50

Purchased

No

No

50381

110

Each

1,013.000 2.0000

FG. 4-01

Bolt

Purchased

Location

Warehouse

Main Warehouse

ST350

105057

110

1013

1013

Each

Loc Qty

72.0000

Loc Code

10-4.27

Warehouse Loc Oty Loc Code Location Main Warehouse ST351 72 113539 22 114227 50

W/O:			W	ORK ORDER CHANG	SES				
DATE	STEP	PRO	DCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date: _	· · · · · · · · · · · · · · · · · · ·
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NCR:		,	WORK ORI	DER NON-CONFORM	ANCE (NC	R)			
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April 21, 2010 10:06:15 AM

Work Order ID: 57981

Parent Item:

D130-780-011

Parent Item Name:

Aft LH Door Hinge

Comments:

IPP Rev:A 09-02-03 new issue DD verified by:JLM

per DSI 9502 revA DD 10.02.17 verified by:EC



IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Oty: 1.00

Component Item ID/

Item Name

Replacement Mfg/ Item ID

Purch Purchased

Purchased

Bin **Primary** Item Location No

No

Last Location

Route Seq ID 110

Unit of Measure Each

Qty on Hand 42.0000

Loc Code

Remaining Qty **Qty To Pick** Issued 2.0000

Date Status Issued

NUT

Warehouse Location

Main Warehouse

ST314 113845

Main Warehouse

ST349

114341

20 110 Each

Loc Qty

56

6

Loc Oty

22

22

20

56.0000

Loc Code

2.0000



Warehouse Location Main Warehouse ST359

112794

113121 113288

20 30

W/O:			WC	ORK ORDER CHANGI	ES			·
DATE	STEP	PRO	OCEDURE CHA		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	lo DQA:	Date: _	
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			,					
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April 21, 2010 10:06:15 AM

Page 6

Work Order ID: 57981

Parent Item:

D130-780-011

Parent Item Name:

Aft LH Door Hinge

Comments:

IPP Rev:A 09-02-03 new issue DD verified by:JLM

per DSI 9502 revA DD 10.02.17 verified by:EC



Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

AN970-4

Replacement Mfg/ Item ID Purch

Purchased

Primary Item Location No

Last Location

IPP Rev:B as

Route Seq ID 110

Unit of Measure Each

Qty on Hand 135.0000 2.0000

Remaining Qty To Pick

Qty Issued Date Issued

Status

Washer	

Purchased

No

No

110

Loc Qty

Loc Qty

Loc Code

135 135

Each

1,089.000 5.0000

Loc Code

10-4-278

10-4-27

MS24665-2-12

COTTER PIN

Purchased:

Location

112991

Main Warehouse

ST300

Warehouse

Warehouse

Location Main Warehouse ST349

> 113537 113644

110

984 Each

1089

105

Loc Code

117.0000 2.0000

10-4-2

Warehouse Location Main Warehouse

ST309

111499

117

Loc Oty

117

W/O:			٧	VORK ORDER CHANGE	ES	<u> </u>			
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	_ Disposit	ion:	QA: N/C CI	osed:		Date:	
NCR:		. W	ORK OR	DER NON-CONFORMA	NCE (NCF	R)			
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		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
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April 21, 2010 10:06:15 AM

Work Order ID: 57981

Parent Item:

D130-780-011

Parent Item Name:

Aft LH Door Hinge

Comments:

IPP Rev:A 09-02-03 new issue DD verified by:JLM

per DSI 9502 revA DD 10.02.17 verified by:EC



IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

MS24694-S46

Replacement Mfg/ Item ID

Purch Purchased Bin Primary Item Location No

Last Location

Route Seq ID 110

Unit of Measure Each

Qty on Hand 85.0000

Remaining **Qty To Pick** .3.0000

Qty Issued Date Issued

Status

SCREW

Warehouse Location

Main Warehouse ST289

111499

Loc Oty

Loc Code

Loc Code

NAS1149D0363J

Purchased

No

85

85 110 Each

1,694.000 -8.0000 -

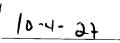


Washer

No

Warehouse Loc Oty Location Main Warehouse ST298 1694 113288 18 114292 1676 110 Each

1,236.000 2.0000



Purchased Washer

> Warehouse Location Main Warehouse ST298 113706

Loc Oty

Loc Code

1236 1236

W/O:			V	VORK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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April 21, 2010 10:06:15 AM

Page 8

Work Order ID: 57981

Parent Item:

D130-780-011

Parent Item Name:

Aft LH Door Hinge

Comments:

IPP Rev:A 09-02-03 new issue DD verified by:JLM

per DSI 9502 revA DD 10.02.17 verified by:EC



IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D3622-1

Ball Stud

Replacement Mfg/ Item ID Purch

Mfg/ Bin
Purch Item
Manufactured No

Primary
n Location

Last Location

Route Seq ID

110

Unit of Qty on Measure Hand Each 25.0000

Remaining Qty To Pick 2.0000 Qty Issued Date Issued

Status

. .

10-21-6-01

Manufactured No

55199

<u>Location</u>

Main Warehouse

ST074

Warehouse

25 25

Loc Oty

25 Each 23.0000

Loc Code

Loc Code

0000

10-4-279

Bracket

MS21042L5

Purchased

No

. T ...

 Warehouse
 Loc Oty

 Location
 Image: Comparison of the comparison

442.0000



10-4-27

\$

<u>Warehouse</u>	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST300	442		
113523	26		
113537	116		2
114108	200		
114437	100		

	•								
W/O:			M	ORK ORDER CHANGE	ES				
DATE	STEP	PROCI	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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·									
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	
		solution:							
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
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April 21, 2010 10:06:15 AM

Page 9

Work Order ID: 57981

Parent Item:

D130-780-011

Parent Item Name:

Aft LH Door Hinge

Comments:

IPP Rev:A 09-02-03 new issue DD verified by:JLM

per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Oty: 1.00

Component Item ID/

Item Name NAS1149D0563J Replacement Mfg/ Item ID

Purch Purchased Bin Primary Item Location No

Last Location

Route Seq ID 110

Unit of Measure Each

Oty on Hand 1,873.000 2.0000

Remaining Qty To Pick

Qty Issued

Date Issued

Status

Washer

Warehouse

Loc Oty Loc Code

Location

Main Warehouse

ST298 113524

113706

1873

44 1829

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W/O:				V	ORK ORDER CH	IANGES					
DATE	STEP	P	PROCI	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:									
	Reso	lution:		Disposit	ion:	QA	: N/C Cld	sed:	 	Date:	
NCR:			WC	ORK ORI	DER NON-CONF	ORMANCE	(NCR)			***************************************
DATE	STEP	Description of NC Section A	i	Initial Chief Eng	Corrective Action Action Descri	Section B ption	Sign & Date	- Verific Section		Approval Chief Eng	Approval QC Inspector
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HEFERENCE ONLY

IIN-D130-780 Page 32 of 34



5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X				- (· · · · · · · · · · · · · · · · · · ·	D130-780-041	SPACEPOD™ LH, EC 130 B4
	Х						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
· '	1	<u>``</u>	Х	1			D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1			~	Х		D130-780-013	SWITCH RELOCATION KIT
· · · · · ·				, 1		X	D130-780-015	CLOSEQUT KIT
·					· · · · · · · · · · · · · · · · · · ·			
2	2			. i			D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1		<u>-</u>				D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1 1					D3186-3	SPACEPOD™ DOOR, LH
<u> </u>			1			†	D3186-4	SPACEPOD™ DOOR, RH
1	 			 			D3798-041	FLOOR
	1				-		D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
-	1				_		D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1	; ;					D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1	Ì					D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2.						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38	:			,		AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7	1					MS24694S67	SCREW
1	1	1		Ì			MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4			<u> </u>	NAS1149DN832J	WASHER
3	3)					NAS1149D0563J	WASHER
		, 2	2		<u></u>		NAS1515H3	NYLON WASHER
-		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10	1					AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10	1		<u> </u>			MS21059L3	NUTPLATE
	1	[

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Revision: B

Date: 09.06.11

W/O:			W	ORK ORDER CHANGE	ES			
DATE	STEP	PROCI	EDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•					,
			·				<u> </u>	
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes N	lo DQA:	Date: _	
	Re	esolution:					Date: _	
NCR:		WC	ORK ORE	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	n B Sign &	Verification	Approval	Approval
	•	Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector
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DART AEROSPACE LTD.

REFERENCE ONLY

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-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
				,	1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
	 			1	24		D3600-1	TIE-WRAP MOUNT
					24		M22759/41-22-9	WIRE
					_FT		14122133141-22-3	771112
		1*	1*				D2464-1250	NEOPRENE SEAL
			•				D2404-1200	HEOT HENCE OF IL
1**		1*					D3837-3	DECAL
	1**		1*	banana			D3837-4	DECAL
·								
		2*	2*				D2586	LATCH
		2*	2*	11		:	D2585	MOUNTING CHANNEL
		2"	2*				D2621	LATCH PLATE
	<u> </u>	2*	2*	4			MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
	<u> </u>	2*	2*				MS21042L3	NUT (or MS21042-3)
	1					-		
		1:	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		B*	8*				MS21042L08	NUT
		1=	1*				D3557-1	BRACKET
		2"	2*				D2228	BACKING PLATE
		í*	1*				D3554-7	BALL STUD
		1	1*				NAS1149D0563J	WASHER
		15	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		.2*	2*	.,			AN526C832R10	SCREW
		A.	4*				NAS1149DN832J	WASHER
	ļ	.4*	4*				MS21042L08	NUT
	0.00	<u> </u>					D2227	STRIKER PLATE
2**	2***	ļ					D2237 MS20426AD4-5	RIVET
4**	4 ""-	<u> </u>					WI32U420AU4-3	NIVLI
2**	2**	i				-	D3538-1	HINGE BRACKET
2**	2**		i -				D2179	HINGE BRACKET PLATE
4**	4**	<u> </u>					AN526C832R24	SCREW
4**	4**	<u> </u>				 	NAS1149DN832J	WASHER
4**	4**	-					MS21042L08	NUT
		1						
		i		1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
	1	1		1	,		D3813-043 /	HINGE ASSEMBLY, LOWER DOOR
	1	Ì		2***			D3518-3	ROD END

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Revision: B

Date: 09.06.11

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W/O:			1	WORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE C	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					:				
Part No	<u> </u>	PAR #:	Fault Ca	ategory:	NCR: Ye	s No DQ	A:	Date:	
					QA: N/C Closed: Date:				
NCR:			WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		Section C	Chief Eng	QC Inspector
		·			. 10		<i>*</i> ;	-	
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DART AEROSPACE LTD.

REFERENCE ONLY

IIN-D130-780 Page 34 of 34

	<u> </u>		,	*		· · · · ·		<u> </u>
-041	-042	-043	-044	-011	-013	-015	Part Number	Description
7.				2***			_NAS509-6	NUT
				.11	4. 2 2. 18 X		¶D3814-1	HINGE, UPPER AIRFRAME
							D3814-3	HINGE, LOWER AIRFRAME
				2	الالسور		D38,16-1,	SPACER
				4	-	Constitution of	D3816-37	SPACER
			 				D3817-041	ANCHOR PLATE
							¥AN3-5A¥	BOLT
				333		W. 200	MAN3-7A	BOLT
	<u> </u>	ļ.		22	9	to the state of th	AN310-4	CASTLE NUT
		-	-	.2	Open State of the	in the	AN4-17	BOLT
			 	52		ACCOUNT OF THE PARTY OF	AN970-4'	WASHER
	-	i		5			MS21042L3	
	<u> </u>	<u> </u>		#2	**************************************	Depart green	*MS24665-212 /	COTTER PIN
		 	-	-3 dQ		3	MS24694S46	SCREW
<u></u>	-	 			m wini		NAS1149D0363J	WASHER
· · · · · ·	· · ·	 	 	2191			NAS1149D0463J	WASHER
			 	10-5-5-				
		ļ		1			D3552-7	GAS SPRING
			 	,2,,,,		71.5	D3622-1 /	BALL STUD
		ļ		1		650/1670/1676	D3820-1-/	DOOR SUPPORT
	 	 		2.4	, manufic (Account)	446.3581.3841	MS21042L5 /	NUT
· · · · · · · · · · · · · · · · · · ·		 	-		95.83 mg	103	NAS1149D0563J	WASHER
 		ļ						
	 	 		1.13	Danage and a	A CONTRACTOR OF THE PARTY OF TH	D3892-1	SEAL
	 	 	 	F. 16 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	SECTION SECTION OF	1	D3983-1	OUTER CLOSEOUT
· · · · · · · · · · · · · · · · · · ·		 		 		1	D3983-3	INNER CLOSEOUT
	 	 	 	 	ļ	1	D3983-5	HINGE CLOSEOUT
	 		 	 	 	1	D3983-047	CLOSEOUT ATTACHMENT
	 	<u> </u>	 	 	 	1	D3983-9	SPACER
-	 		\vdash	 	 	2	AN525-10R6	SCREW
	 	<u> </u>	 	 -	-	1	AN525-10R24	SCREW
	 	 	<u> </u>	1	 	1	NAS1149D0363J	WASHER
		ļ	 	 	-	1	MS21042L3	NUT
	ł	l	1	l .	1	<u> </u>	INIOZ TUTZEU	1001

^{*} Pre-installed on D3186-3/-4 Spacepod™ Door

^{**} Pre-installed on D3188-5/-6 Spacepod™

^{***} Pre-installed on D3813-041/-043 Hinge Assemblies

	•								
W/O:			V	VORK ORDER CHANGE	S			,	
DATE	STEP	PRO	OCEDURE CH	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								!	
Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	, .	
	Res	solution:	Disposit	tion:	QA: N/C Closed: I			Date:	
NCR:			NORK OR	DER NON-CONFORMAL	NCE (NCR	•			
DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval	
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector	
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							€. ****		
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B OR LATER APPROVED REVISION AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER ACCEPTED REVISION

REF. TCCA STC: SH93-88 REF. FAA STC: SR00098NY REF. EASA.IM.R.S.01292

The purpose of this DSI is to provide an alternate door prop for the D130-780-011 LH STORE POPULATION OF THE PURPOSE OF THE PU

In service experience has shown that LH Sliding Doors may have significantly more weight associated with their installation due to executive style finishing versus the standard utility LH Sliding Door. This extra weight requires a more powerful door prop to operate the door.

For D130-780-011 at CHG 003, the D3552-7 door prop is replaced with a D3552-13 door prop as follows:

IS

-041 -042 -043 -044 -01	-013 -015	PART NUMBER	DESCRIPTION
1	, .	D3552-13	DOOR PROP
L.,			

-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
				1			D3552-7	DOOR PROP

Customers with D130-780-011 at CHG 002 or earlier, may procure the DSI 9502-011 kit to replace the D3552-7 door prop with a D3552-13 door prop as follows:

	4111	ì	
•	. X	DSI 9502-011	REPLACEMENT DOOR PROP KIT
ĺ	1 .	D3552-13	DOOR PROP

Remove the D3552-7 door prop from the ball studs
 Install the D3552-13 per IIN-D130-780 and ICA-D130-780.
 Update parts list in IIN-D130-780 and ICA-D130-780 to reflect the part number change.
 Make an entry in the technical record of the aircraft indicating that DSI 9502 has been accomplished.

Weight and Balance change associated with this DSI is negligible.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

APPROVED

DATE CERT. NO .: ISSUE NO .:

A	NEW IS	SUE	6	10.02.03				
REV.		DESCRIPTION BY						
DESIGN	1	45	DART AEROS	PACEL	LTD			
DRAW	1	6 5	HAWKESBURY, ONTARIO, CANADA					
CHECKED		-4	DRAWING NO.		REV. A			
MFG. APPR.		N/A	DSI 9502		SHEET 1 OF 1			
APPROVED		4	TITLE		SCALE			
DE APPR.			REPLACEMENT DOOR PROP NTS					
DATE	10.0	2.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND COPPEDETUL AND IS EUPPLIED OF THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OF COMMUNICATED TO ANY OTHER PERSON MITHELIT					

Dart Ae	rospace	e Ltd	√									
W/O:			1	W	ORK ORDER C	HANGES						
DATE	STEP		PR	OCEDURE CH	,		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		<u> </u> 		•								
Part No:		PAR #:	Fault Cat	egory:	NC	NCR: Yes No DQA: Date:						
	R	esolution:		Dispositi	on:	QA: N/C Closed: Date:						
NCR:				WORK ORE	DER NON-CONF	FORMANC	E (NCR)					
DATE	STEP	De	escription of NC		Section B	Verification Approva			Approval			
DATE	SIEP		Section A	Initial Chief Eng	Action Desc Chief Eng	ription	Sign & Date	Section C	Chief Eng	QC Inspector		
						•				-		
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